



Dart Aerospace Ltd.
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Tel (613) 632-5200

D3913-041
Job Sheet 177343



Part No: D3913-041

Job Qty: 1 ea

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/10/18

Job Tracking No:

Due Date: 5/30/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		5/30/18	0.00	0.00	Start Up Large Fab-5		D.M.L. 18-7-12
100	Large Fab	1 pcs		5/30/18	0.00	10.00	Large Fab 1		C. 18-7-12
110	QC	1 pcs		5/30/18	0.00	0.00	QC9		18-7-12
120	QC	1 pcs		5/30/18	0.00	0.00	QC5		18-7-12
125	HandFinish	1 pcs		5/30/18	0.00	0.29	HandFinish2		B. 18-7-12
130	Powdercoat	1 pcs		5/30/18	0.00	0.93	Powdercoat2		B. 18-7-12
135	Packaging	1 pcs		5/30/18	0.00	0.00	Packaging1		18-7-12
140	QC	1 pcs		5/30/18	0.00	0.00	QC3		18-7-12
150	HandFinish	1 pcs		5/30/18	0.00	0.50	HandFinish4		18-7-12
160	QC	1 pcs		5/30/18	0.00	0.00	QC5		18-7-12
170	Packaging	1 pcs		5/30/18	0.00	0.00	Packaging3-2		18-7-12
180	QC21-SA	1 Ea		5/30/18	0.00	0.00	QC21		21 JUL 18 2018

Part Op 100 - 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect before welding mesh*** 2-Cut D4020-1 base
Descriptions: mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners
holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket*** 4-
Weld D4672-1 blanking plates as per dwg
130 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat
150 - Pick Kit

M138839 START: 2:20

QUTI 375°

FINISH 2:35



Container No: S091470



Part: D3913-041

Job No: 177343

Serial No/Batch: S091470

Revision:

Inspector:

Exp Date:

Instructions:

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Date: 07/12/18

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	5068733
D3913-1	Rib	1 Ea (1 ea)	90-Start up Operation	508148
D3913-15	Wide Handle Plate	1 Ea (1 ea)	90-Start up Operation	5068414
D3913-3	Rib	1 Ea (1 ea)	90-Start up Operation	5080944
D3913-7	Rib	2 Ea (2 ea)	90-Start up Operation	5079285
D3913-9	Hinge Rib	1 Ea (1 ea)	90-Start up Operation	5084677
D3916-041	Rib Assembly	2 Ea (2 ea)	90-Start up Operation	5080509
D3916-5	Light Rib	3 Ea (3 ea)	90-Start up Operation	5084063
D4016-1	Hinge Half, Base	3 Ea (3 ea)	90-Start up Operation	5083477
D4017-7	Rib	3 Ea (3 ea)	90-Start up Operation	5068769
D4017-9	Rib	2 Ea (2 ea)	90-Start up Operation	5067578
D4020-11	End Mesh, Basket	2 Ea (2 ea)	90-Start up Operation	5071126 x1
D4021-1	Handle Plate	3 Ea (3 ea)	90-Start up Operation	5068416
D4034-041	Aft Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation	5083016
D4034-043	Fwd Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation	5080939
D4672-1	Blanking Plate	2 Ea (2 ea)	90-Start up Operation	5054936
M304EX0.75-16F	Expanded Metal Flat SS	33 sf (33 ea)	90-Start up Operation	5070544
AN3-10A	Bolt	6 Ea (6 ea)	150-HandFinish	5078251
D2931	Bumper	2 Ea (2 ea)	150-HandFinish	F86435
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-HandFinish	5076007-1
MS21042L3	Nut	6 Ea (6 ea)	150-HandFinish	5078252
NAS1149F0332P	Washer	12 Ea (12 ea)	150-HandFinish	5071415
D4021-5	Blanking Plate	2 Ea (2 ea)	150-HandFinish	5067452

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	69	0
	D3913-1	1	8	0
	D3913-15	1	20	0
	D3913-3	1	10	0
	D3913-7	2	13	0
	D3913-9	1	13	0
	D3916-041	2	16	0
	D3916-5	3	24	0
	D4016-1	3	19	0
	D4017-7	3	81	0
	D4017-9	2	24	0
	D4020-11	2	15	0
	D4021-1	3	30	0
	D4034-041	1	2	0
	D4034-043	1	2	0
	D4672-1	2	36	0
	M304EX0.75-16F	33	611	0
150-HandFinish	AN3-10A	6	153	0
	D2931	2	1,058	0
	D4021-5	2	37	0
	MS20600-AD4W3	2	393	0
	MS21042L3	6	1,850	0
	NAS1149F0332P	12	2,993	0

Part Specifications

Specifications could not be found.

Plex 5/10/18 8:20 AM Dart.Gagnon.Michelle

Master Unit 004115



Job No 177343